

Order 837e) Ship 20 Sept



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SEP 11 2018

005417

D350-836-019
Job Sheet 182782



Part No: D350-836-019

Job Qty: 4 ea

Part Name: Crosstube Antenna Mount AS350 / AS355



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEET 7 IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/20/18	9/20/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 13 2018
110	Packaging	4 pcs	9/20/18	9/20/18	0.00	0.00	Packaging1-4		
120	QC	4 pcs	9/20/18	9/20/18	0.00	0.00	QC4		
125	DC	4 pcs	9/20/18	9/20/18	0.00	0.00	DC		
130	Packaging	4 pcs	9/20/18	9/20/18	0.00	0.00	Packaging3-1		
140	QC21-FG	4 Ea	9/20/18	9/20/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile and create labels as per PPP D350-836-019 CH001

Descriptions: 130 - Identify and pack for shipping as per PPP D350-836-019 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-11A	Bolt	8 Ea (2 ea)	90-Start up Operation	5070193
AN4-16A	Bolt	8 Ea (2 ea)	90-Start up Operation	5099494
D2732-030	Rubber Cushion - 3"	8 Ea (2 ea)	90-Start up Operation	5082825
D4853-1	Top Bracket	4 Ea (1 ea)	90-Start up Operation	5041071
D4854-1	Lower Bracket	4 Ea (1 ea)	90-Start up Operation	5110077
D4855-1	Antenna Bracket	4 Ea (1 ea)	90-Start up Operation	5042386
MS21042L4	Nut	16 Ea (4 ea)	90-Start up Operation	5022475
NAS1149D0432J	Washer	32 Ea (8 ea)	90-Start up Operation	503356

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-11A	8	284	0
	AN4-16A	8	518	0
	D2732-030	8	153	0
	D4853-1	4	10	0
	D4854-1	4	0	0
	D4855-1	4	8	0
	MS21042L4	16	4,810	0
	NAS1149D0432J	32	1,092	0

Part Specifications

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																		
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Date : _____	Step #: _____	Effective : _____	MRB (QSI042) Approval _____																																																
Description Work Order _____  DART AEROSPACE Container No: S109673 Part: D350-836-019 Job No: 182782 Serial No/Batch: S109673 Revision: A Inspector: _____ Exp Date: _____ Instructions: _____ Date: 09/12/18			Completed By _____																																																
			Lead hand / Supervisor Approval Verification _____																																																
			QC / QA Coordinator Approval _____																																																
Root Cause <table style="width:100%;"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Centre Not Correct ☐</td> <td>Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Cracks ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cuffs ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crushing ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Heat Treat ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Marks/Chatter ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Drill Holes ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td></td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td>OTHER : _____</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	Centre Not Correct ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Cracks ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Crimp/Kink/Ripple/Wave ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cuffs ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crushing ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Heat Treat ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Wave/Twist in Tube ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Marks/Chatter ☐	Finish ☐	LOA ☐	Product Improvement ☐	Drill Holes ☐	Misread ☐	Substation ☐	Process Improvement ☐		Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER : _____		Jullied _____ ce _____ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	
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Specifications could not be found.

Plex 8/31/18 2:01 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

5. PARTS LIST

Qty -019	Qty -111	Part Number	Description
X		D950-836-019	CROSSTUBE ANTENNA MOUNT KIT AS350/355 (P162-350)
	X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
	1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
	1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
	1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
	1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	AN4-16A	BOLT
2	2	AN4-11A	BOLT
8	8	NAS1149D0432J	WASHER
4	4	MS21042L4	LOCKNUT

PAGE 1 OF 1

Description: CROSSTUBE ANTENNA MOUNT, AS350/355

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